

**Work Order ID 85001**

May-31-12 9:09:39 AM

**\*85001\***

Page 1

Item ID: D212-725-1-111

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: ENGINE MOUNT DECK FITTING

Start Date: 5/31/12 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 5/31/12 Req'd Qty: 2.00

**\*2\***

Customer:

Reference: rework to new rev

Approvals:

Process Plan: 

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D4231	A U/R								
105		0.00							
<b>*105*</b>									
Mill Conv	<b>Memo</b>	0.00							
Conventional Milling Machine	PULL FROM STK: 2 X D212-725-1-111 B45608  REWORK/MILL PER NEW REV.								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*120*</b>									
QC	<b>Memo</b>	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
<b>*130*</b>									
QC	<b>Memo</b>	0.00							
Quality Control									

*Crushed  
parts not  
found per  
JL*

*W  
120710*

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## Quality Control

May-31-12 9:09:39 AM

**Item ID:** D212-725-1-111

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

**Revision ID:**

Stop \*NS2\*

**Item Name:** ENGINE MOUNT DECK FITTING

**Start Date:** 5/31/12      **Start Qty:** 2.00      **\*2\***

**Cust Item ID:**

**Required Date:** 5/31/12      **Req'd Qty:** 2.00      **\*2\***

**Customer:**

**Reference:** rework to new rev

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

[illegible]

# Picklist Print

May-31-12 9:09:39 AM

Page 1

Work Order ID: 85001

Parent Item: D212-725-1-111

Start Date: 5/31/12

Required Date: 5/31/12

Parent Item Name: ENGINE MOUNT DECK FITTING

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 06-12-19 JLM  
IPP Rev:B Added Cad Plating 07-07-23 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D212-725-1-111 ENGINE MOUNT DECK FITTING		Manufactured	No				Each	0.0000		2			

## Linda Lacelle

---

**From:** Jean-Luc Menard <jmenard@dartaero.com>  
**Sent:** May-30-12 1:41 PM  
**To:** 'Linda Lacelle'  
**Subject:** RE: D212-725-1-109/-110/-111 Engine mounts for Eagle Single

Conv milling      mill as per new rev  
Qc2  
Qc8  
I think we will have to re cad plate.

85001

JL

---

**From:** Linda Lacelle [<mailto:llacelle@dartaero.com>]  
**Sent:** Wednesday, May 30, 2012 12:56 PM  
**To:** 'Jean-Luc Menard'  
**Subject:** RE: D212-725-1-109/-110/-111 Engine mounts for Eagle Single

- 45608

Will you take them out of stk pls, write up what has to be done, and I'll make the w/o from that..  
Thx  
L

---

**From:** Jean-Luc Menard [<mailto:jmenard@dartaero.com>]  
**Sent:** May-30-12 12:53 PM  
**To:** 'Linda Lacelle'; 'Roberto Fuentes'  
**Cc:** 'Eric Downing'; 'David Shepherd'; 'Mike Petsche'; 'David Shepherd'; 'Kim Johnston'  
**Subject:** RE: D212-725-1-109/-110/-111 Engine mounts for Eagle Single

Yes we will be able to re-work them.  
JLM

---

**From:** Linda Lacelle [<mailto:llacelle@dartaero.com>]  
**Sent:** Wednesday, May 30, 2012 6:10 AM  
**To:** 'Roberto Fuentes'; 'Jean-Luc Menard '  
**Cc:** 'Eric Downing'; 'David Shepherd'; 'Mike Petsche'; 'David Shepherd'; 'Kim Johnston'  
**Subject:** RE: D212-725-1-109/-110/-111 Engine mounts for Eagle Single

Only 2 x D212-725-1-111 in stk...JL can you let me know if these can be reworked..  
L

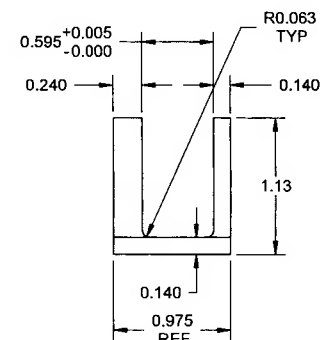
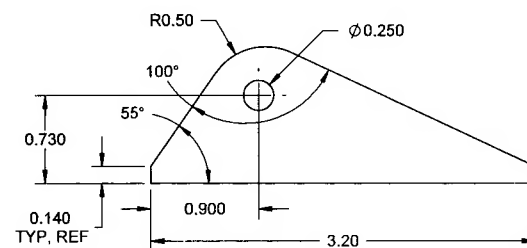
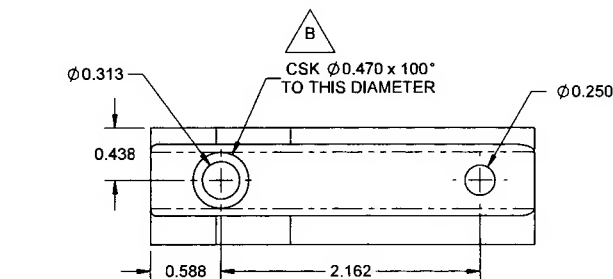
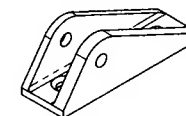
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**From:** Roberto Fuentes [<mailto:rfuentes@dartaero.com>]  
**Sent:** May-29-12 6:47 PM  
**To:** Linda Lacelle  
**Cc:** Jean-Luc Menard ; Eric Downing; David Shepherd; Mike Petsche; David Shepherd; Kim Johnston  
**Subject:** D212-725-1-109/-110/-111 Engine mounts for Eagle Single

Hi Linda,

I just posted D4231-PB2 engine mount drawing for review and approve by production. If there is any W/O in progress need to be updated per this new drawing and check the stock. I just got the feedback from Eagle today.

Thanks,  
Roberto



*also 85007*

# NOTES:

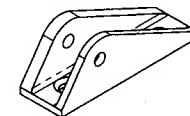
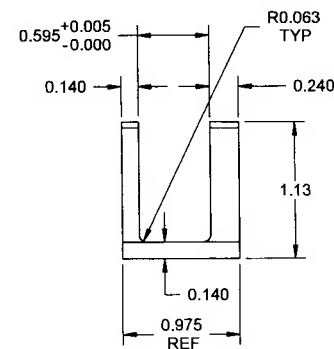
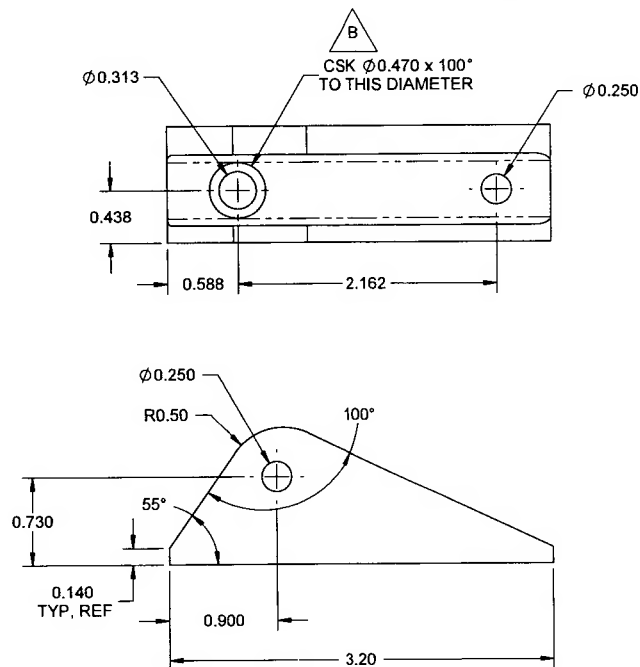
- 1) MATERIAL: AISI 4140 STEEL BAR  
PER MIL-S-5626 OR AMS 6382/6349/6529  
REF DART SPEC. M4140N-B  
OR AISI 4130 STEEL BAR  
PER MIL-S-6758 OR AMS 6345/6348/6370/6528  
REF DART SPEC. M4130N-B  
HEAT TREAT TO MIN. ULTIMATE TENSILE STRENGTH = 125 ksi
- 2) FINISH: CADMIUM PLATE PER AMS-QQ-P-416B, CLASS I, TYPE II
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.30 lbs

## **D212-725-1-109 SMALL ENGINE MOUNT, LH**

## **PRELIMINARY ISSUE**

*7* 12.05.29

PB2	CSK Ø0.470 x 100° WAS Ø0.446 x 45° CHAMFER (ZN D5-1, D5-2)	RF	12.05.29
A	NEW ISSUE	RF	11.02.24
REV.	DESCRIPTION	BY	DATE
DESIGN	JL	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO.	REV. PB2
MFG. APPR.		D4231	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ENGINE MOUNT	NTS
DATE	12.05.29	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



# **D212-725-1-110 SMALL ENGINE MOUNT, RH**

## **PRELIMINARY ISSUE**

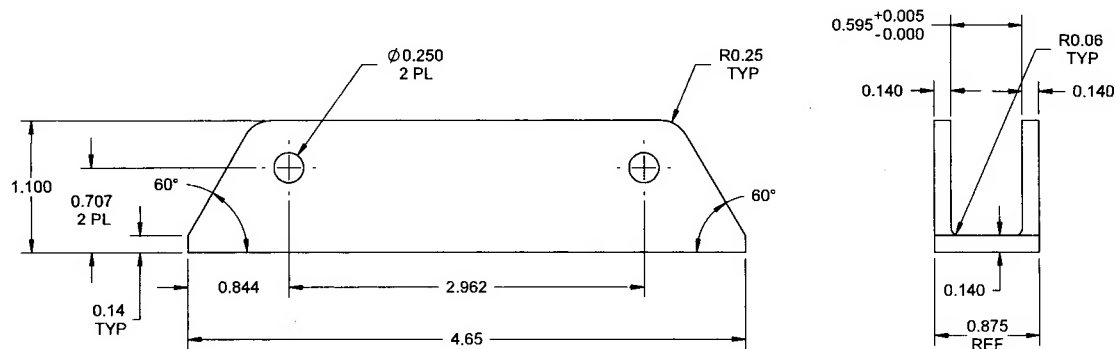
12.05.29

### **NOTES:**

- 1) MATERIAL: AISI 4140 STEEL BAR  
PER MIL-S-5626 OR AMS 6382/6349/6529  
REF DART SPEC. M4140N-B  
OR AISI 4130 STEEL BAR  
PER MIL-S-6758 OR AMS 6345/6348/6370/6528  
REF DART SPEC. M4130N-B  
HEAT TREAT TO MIN. ULTIMATE TENSILE STRENGTH = 125 ksi
- 2) FINISH: CADMIUM PLATE PER AMS-QQ-P-416B, CLASS I, TYPE II
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.30 lbs

DESIGN	JL	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. <b>D4231</b>	REV. PB2
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE <b>ENGINE MOUNT</b>	SCALE NTS
DE APPR.		COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	12.05.29		






## PRELIMINARY ISSUE

**NOTES:**

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HEAT TREAT TO MIN. ULTIMATE TENSILE STRENGTH = 125 ksi
- 2) FINISH: CADMIUM PLATE PER AMS-QQ-P-416B, CLASS I, TYPE II
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.47 lbs

DESIGN	JL	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D4231</b>  TITLE <b>ENGINE MOUNT</b>  COPYRIGHT © 2011 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	REV. PB2
DRAWN	RF		SHEET 3 OF 3
CHECKED			SCALE
MFG. APPR.			NTS
APPROVED			
DE APPR.			
DATE	12.05.29		